

Work Order ID 54799

December 22, 2009 1:24:18 PM



Page 1

Item ID: D3773-1

Accept



Setup Start



Revision ID:

Item Name: Adapter

Stop



Start Date: 12/28/09

Start Qty: 20.00



Cust Item ID:

Required Date: 1/08/10

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 09/12/09 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3773

Rev B

100



BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank 2.700" long

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

1- Mill as per Folio FA740 Rev: AA & Dwg D3773 Rev: B

per dwg D3773

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

on 10/01/09

20 0

10/01/09

20 1

PTO

10/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3773-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: A Date: 10.01.12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: J Date: 10/01/2012

NCR: 54799		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/09	110	On 3rd operation the part moved in the vise when machining. R.C. Part wasn't set properly	PB 0242	Replace Batch # 112752 → Remade new Tooling DT 9570	BB 10/01/09	S 10/01/11	B 0242	S 10/01/11
		on partable so I machine a solid jaws. / Tooling						

NOTE: Date & initial all entries

Work Order ID 54799

December 22, 2009 1:24:19 PM



Page 2

Item ID: D3773-1

Accept



Setup Start



Revision ID:

Item Name: Adapter

Stop



Start Date: 12/28/09 Start Qty: 20.00



Cust Item ID:

Required Date: 1/08/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

QC8- Inspect parts - second check

0.00

10-01-11

Quality Control

140



Packaging

Packaging

Identify as per dwg & Stock Location 250A

0.00

Memo

0.00

10-1-11 20x

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/12 20

10-1-11

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 1:24:18 PM

Page 1

Work Order ID: 54799



Parent Item: D3773-1



Parent Item Name: Adapter

Start Date: 12/28/09

Required Date: 1/08/10

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	25.7300	4.7368			

304 bar 1.50 X1.50



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	25.73
108381	13.23
→ 112752	12.5

4.7368 2nd 01/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

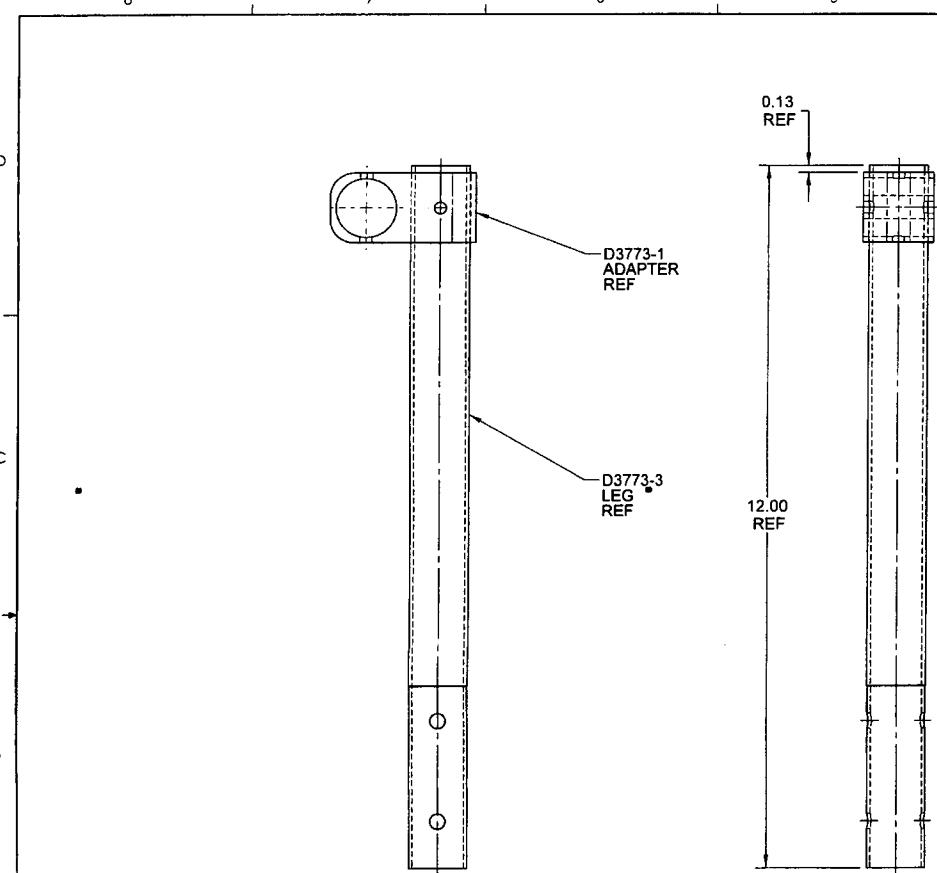
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	S4799
Description: Adapter	Part Number:	D3773-1
Inspection Dwg: D3773 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>SB</i>	Audited by:	<i>MF</i>	Prototype Approval:	N/A
Date:	<i>01/01/09</i>	Date:	<i>10.01.11</i>	Date:	N/A



NOTES:

2) FINISH: NONE

3) TOLERANCES:

4) UNITS: INCHES UNLESS OTHERWISE NOTED

4) UNITS: INCHES
5) BREAK SHARP

6) IDENTIFICATION: N/A

7) WEIGHT: D3773-1, 0.40 lbs

D3773-3, 0.69 lbs

D3773-041. 1.04 lbs

8) WFLD: PER DART QSI 004

9) IF NECESSARY GRIND INTER

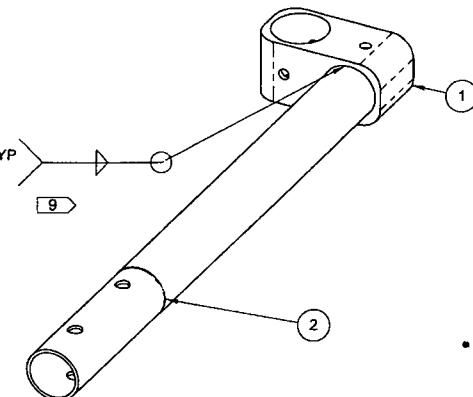
9, II NECESSARY GRIND INTER.

8

8 , 9

D3773-041 HEADREST ASSEMBLY

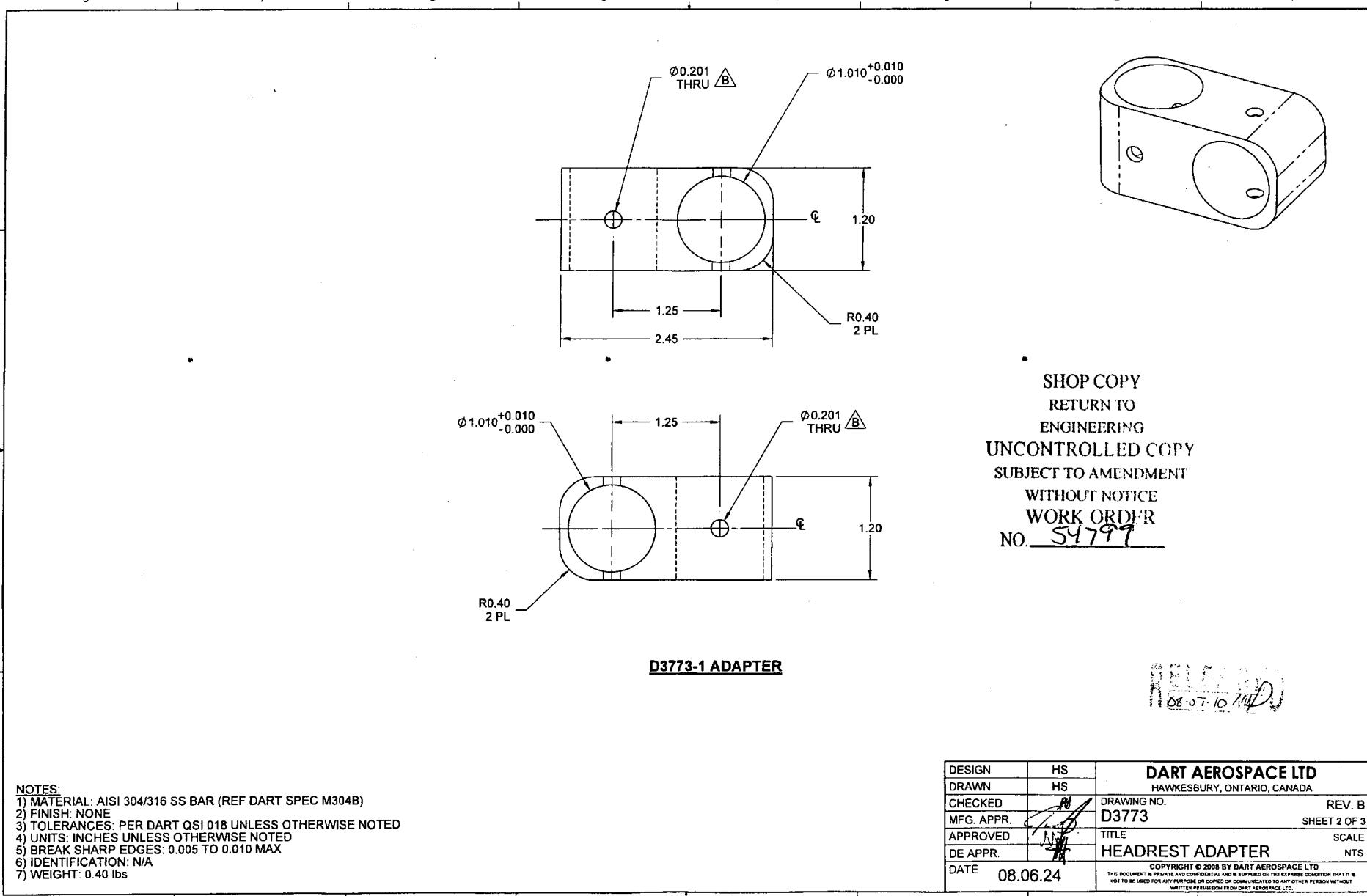
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDME
WITHOUT NOTICE
WORK ORDER
NO. 54799
C Left 12123



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

2018-07-10 14:00

B	CHANGE HOLE SIZE TO 0.201		HS	08.06.24
A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	HS	DRAWING NO.		
CHECKED		D3773	REV. B	
MFG. APPR.		TITLE	SHEET 1 OF 3	
APPROVED		SCALE		
DE APPR.		NTS		
DATE	08.06.24	HEADREST ADAPTER		
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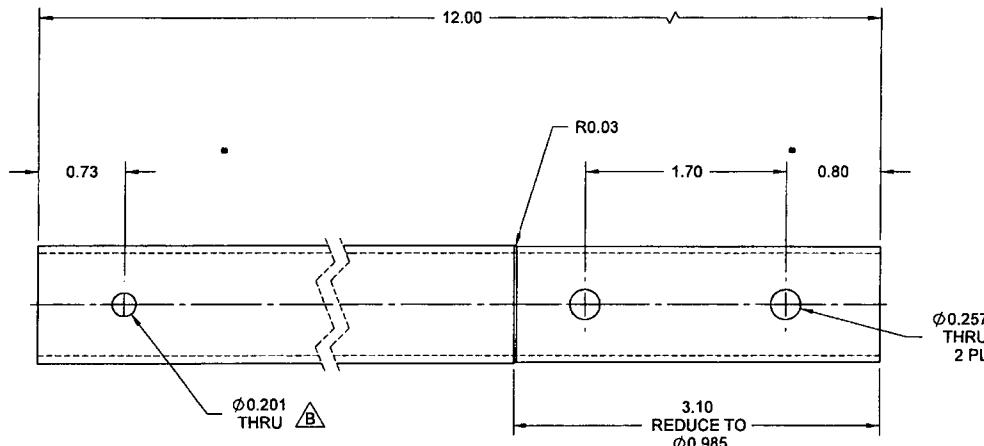
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B

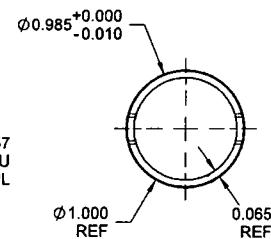
B

A

A

D3773-3 LEG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54799



NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	HS	DART AEROSPACE LTD
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA
CHECKED	RJ	DRAWING NO. REV. B
MFG. APPR.		D3773 SHEET 3 OF 3
APPROVED	AM	TITLE SCALE
DE APPR.		HEADREST ADAPTER NTS
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8 7 6 5 4 3 2 1